

Date: Thursday, 6/29/2006 8:27:55 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)					
Job Number	: 27761	Part Number	: D2571					
Estimate Number	: 10530	Drawing Number	: D2571 REV E					
P.O. Number	: N/A	Project Number	: N/A					
This Issue	: 6/29/2006	Drawing Revision	: E					
Prshrt Rev.	: NC	Material	: N/A					
First Issue	: N/A	Due Date	: 7/15/2006					
Previous Run	: 27056	Qty:	16 Um: Each					
Written By	<i>See COMMENT Below</i>							
Checked & Approved By	<i>JG 06 06 29</i>							
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
		 <i>1523481 * 16 + 1</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <i>✓</i>

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 <i>5.G 1EP 06/07/18 * 16</i>

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		 <i>5.G 1EP 06/07/18 * 16</i>
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>5.G 1EP 06/07/18 * 16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27761		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.07.10	2.2	Saddle-to-skidtube holes offset to one side. 0.500 dimension is 0.475	JP 06.07.10 per QSI42	SCRAP - destroy Ref DS email Replace.	ER dd67/16 06.07.10	J 0607-3	JP 06.07.10 per QSI42	J 06.07.10

Part No: D2571

PAR #: N/A

Fault Category: Max - One

NCR: Yes No DQA: AA

Date: 06.07.20

NOTE: Date & initial all entries

QA: N/C Closed: AA

Date: 06.07.20

Date: Thursday, 6/29/2006 8:27:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27761

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06-07-18

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SA 06-07-18

(16)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/19 (16)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

0.m 06-07-18

(16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 342

PA 06/1/20 (16)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PA 06-07-20

Job Completion



SA 06-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27761
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				1	2	3	4			
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441			
B	1.745	1.755		1.748	1.747	1.747	1.746			
C	3.495	3.505		3.496	3.496	3.497	3.499			
D	1.745	1.755		1.748	1.747	1.747	1.746			
E	7.990	8.010		7.993	7.996	7.998	7.997			
F	0.490	0.510		0.493	0.494	0.495	0.499			
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257			
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377			
I	0.490	0.510		0.492	0.493	0.494	0.495			
J	1.174	1.184		1.175	1.177	1.177	1.180			
K	0.558	0.578		0.560	0.561	0.562	0.563			
L	1.174	1.184		1.175	1.175	1.178	1.178			
M	1.490	1.500		1.493	1.494	1.495	1.494			
N	2.495	2.505		2.498	2.497	2.498	2.499			
O	3.869	3.879		3.873	3.872	3.871	3.872			
P	0.115	0.135		0.126	0.127	0.126	0.127			
Q	0.115	0.135		0.135	0.135	0.135	0.135			
R	0.240	0.260		0.253	0.254	0.254	0.255			
S	0.115	0.135		0.118	0.119	0.120	0.121			
T	0.178	0.198		0.188	0.188	0.188	0.188			
U	2.940	2.980		2.960	2.961	2.960	2.961			
V	0.230	0.250		0.236	0.237	0.236	0.237			
W	0.115	0.135		0.115	0.118	0.118	0.119			
X	0.308	0.313		0.310	0.310	0.310	0.310			
Y	0.760	0.765		0.765	0.765	0.765	0.765			
Z	0.352	0.372		0.367	0.364	0.364	0.365			
AA	0.470	0.530		0.500	0.500	0.500	0.500			
AB	0.615	0.635		0.623	0.624	0.624	0.624			
AC	0.053	0.073		0.063	0.063	0.063	0.063			
AD	0.240	0.260		0.244	0.244	0.243	0.242			
AE	1.375	1.395		1.388	1.385	1.385	1.385			
AF	0.115	0.135		0.135	0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260	0.260			
AH	0.240	0.260		0.249	0.248	0.247	0.247			
AI	2.000	2.020		2.023	2.020	2.020	2.020			
AJ	0.023	0.043		0.030	0.030	0.030	0.030			
Accept/Reject										

Measured by:	EN/J.G	Audited by:	SD
Date:	06/07/10	Date:	06.07.10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD	Work Order:	27761
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.747	1.747	1.745		
C	3.495	3.505		3.499	3.498	3.497	3.498		
D	1.745	1.755		1.747	1.748	1.749	1.745		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		0.499	0.498	0.497	0.499		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.497	0.498	0.495		
J	1.174	1.184		1.179	1.180	1.179	1.175		
K	0.558	0.578		0.569	0.568	0.567	0.559		
L	1.174	1.184		1.178	1.180	1.178	1.175		
M	1.490	1.500		1.498	1.497	1.496	1.495		
N	2.495	2.505		2.501	2.499	2.497	2.497		
O	3.869	3.879		3.870	3.871	3.871	3.867		
P	0.115	0.135		0.120	0.121	0.120	0.126		
Q	0.115	0.135		0.124	0.124	0.121	0.135		
R	0.240	0.260		0.244	0.250	0.248	0.253		
S	0.115	0.135		0.130	0.131	0.129	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.960	2.961	2.960		
V	0.230	0.250		0.241	0.243	0.241	0.238		
W	0.115	0.135		0.130	0.130	0.130	0.139		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.365	0.365	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.621	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.256	0.249	0.248	0.254		
AE	1.375	1.395		1.384	1.385	1.384	1.385		
AF	0.115	0.135		0.130	0.129	0.128	0.135		
AG	0.240	0.280		0.260	0.250	0.247	0.260		
AH	0.240	0.260		0.248	0.247	0.246	0.248		
AI	2.000	2.020		2.000	2.001	2.003	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	S.G/E	Audited by:	SD
Date:	06.07.13	Date:	06.07.13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD	Work Order:	27761
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.745	1.746	1.746		
C	3.495	3.505		3.500	3.493	3.495	3.495		
D	1.745	1.755		1.745	1.745	1.746	1.746		
E	7.990	8.010		8.002	8.002	8.001	8.002		
F	0.490	0.510		0.498	0.496	0.496	0.493		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.497	0.494	0.496	0.496		
J	1.174	1.184		1.176	1.176	1.175	1.178		
K	0.558	0.578		0.564	0.564	0.560	0.560		
L	1.174	1.184		1.176	1.176	1.175	1.178		
M	1.490	1.500		1.491	1.494	1.492	1.496		
N	2.495	2.505		2.495	2.499	2.497	2.497		
O	3.869	3.879		3.869	3.873	3.869	3.872		
P	0.115	0.135		0.126	0.126	0.123	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.252	0.252		
S	0.115	0.135		0.127	0.126	0.124	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.233	0.237	0.239		
W	0.115	0.135		0.125	0.121	0.122	0.123		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.363	0.360	0.365		
AA	0.470	0.530		0.500	0.500	0.502	0.500		
AB	0.615	0.635		0.625	0.622	0.628	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.248	0.246	0.246		
AE	1.375	1.395		1.385	1.384	1.385	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.251	0.248	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP	Audited by:	SD
Date:	06/07/14	Date:	06/07/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

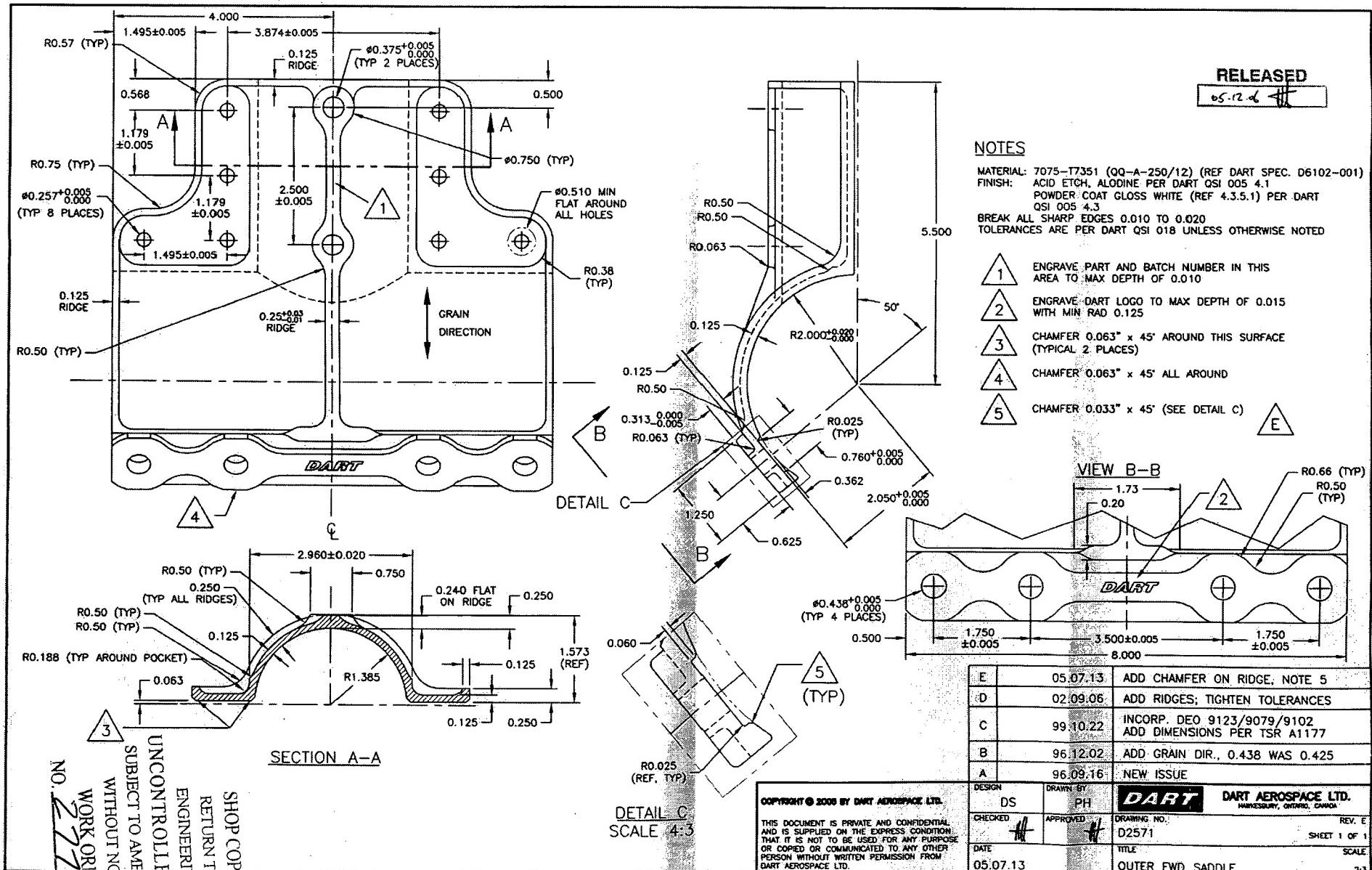
DART AEROSPACE LTD	Work Order:	27761
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

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B	1.745	1.755		1.748	1.747	1.747	1.746		
C	3.495	3.505		3.501	3.500	3.499	3.498		
D	1.745	1.755		1.747	1.746	1.747	1.746		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		0.500	0.499	0.499	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.494	0.498	0.497		
J	1.174	1.184		1.180	1.179	1.178	1.179		
K	0.558	0.578		0.568	0.569	0.569	0.568		
L	1.174	1.184		1.180	1.180	1.179	1.179		
M	1.490	1.500		1.501	1.501	1.500	1.501		
N	2.495	2.505		2.498	2.497	2.498	2.497		
O	3.869	3.879		3.874	3.874	3.873	3.873		
P	0.115	0.135		0.130	0.132	0.131	0.132		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.248	0.247	0.246		
S	0.115	0.135		0.120	0.127	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.242	0.241	0.240		
W	0.115	0.135		0.121	0.123	0.127	0.126		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.363	0.363	0.363		
AA	0.470	0.530		0.520	0.520	0.520	0.520		
AB	0.615	0.635		0.624	0.623	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.248	0.247		
AE	1.375	1.395		1.385	1.385	1.386	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.247	0.246	0.247		
AI	2.000	2.020		2.006	2.000	2.001	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G /	Audited by:	SD
Date:	06/07/15	Date:	06.07.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD



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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: July 10, 2006 2:25 PM
To: 'Chris Provencal'
Subject: RE: NCR 205 Saddles

I agree. Scrap them.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, July 10, 2006 11:30 AM
To: David Shepherd (David Shepherd)
Cc: 'Serge Shahbazian'
Subject: NCR 205 Saddles

David:

D2572 Saddle, the saddle-to-skidtube holes are offset 0.016" to one side.

D2571 Saddle, the saddle-to-skidtube holes are offset 0.025" to one side.

I would be tempted to scrap them, at least the 0.025" one because I know how hard it is already to assembly the bushings into the saddles and have everything line up.

-Chris